







Date: Friday, 22/09/2006 10:46:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 24266E	
Estimate Number : 10283	
P.O. Number : N/A	Part Number : D31991
This Issue : 22/09/2006 S.O. No. : N/A	Drawing Number : D3199 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 11/11/2005 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 23721E	Material : N/A
Written By : _____	Due Date : 30/11/2005 Qty: 36 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:C` Removed Scribing 05-11-05 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S20GA 304/316 .040 Sheet
	
Comment: Qty.: 0.0990 sf(s)/Unit Total : 3.5640 sf(s) 304/316 .040 Sheet <u>BT# H101264</u>	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET <u>SAD 06:09:24 37</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 06:09:24 37</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>06:09:24 converted (37)</u>	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE <u>SP 06/10/12 (37)</u>	
1-Form as per Dwg D3199	
2-Deburr if necessary <u>MF. 06/09/26 (37)</u>	

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Drawing Name: BRACKET

Job Number: 24266E

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10-13 (37)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Q.M. 06/10/20 (37)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/23 (37)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST/38

06/10/23 (37)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/23 (37)

Job Completion



U 06/10/23

Date: Tuesday, 19/09/2006 10:17:33 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 24266E		
Estimate Number	: 10283		
P.O. Number	:	Part Number	: D31991
This Issue	: 19/09/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3199 REV A1
First Issue	: 11/11/2005	Project Number	:
Previous Run	: 23721E	Drawing Revision	: A1
		Material	:
Written By	:	Due Date	: 30/11/2005
Checked & Approved By	:	Qty:	36
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor Laser Cut D3199-1 bracket per Dwg D3199

Material release note is required

M3045204A 0.001
W21991
W21991

2.0	D31991F	Bracket
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Comment: Qty.: 1.0000 (s)/Unit Total: 36.0000 (s)
Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

QC 2

QC 8

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	BRAKE NC	NC BRAKE
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small fab



Comment: NC BRAKE

1-Form as per Dwg D3199

2-Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 24266E

Part Number: D31991

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

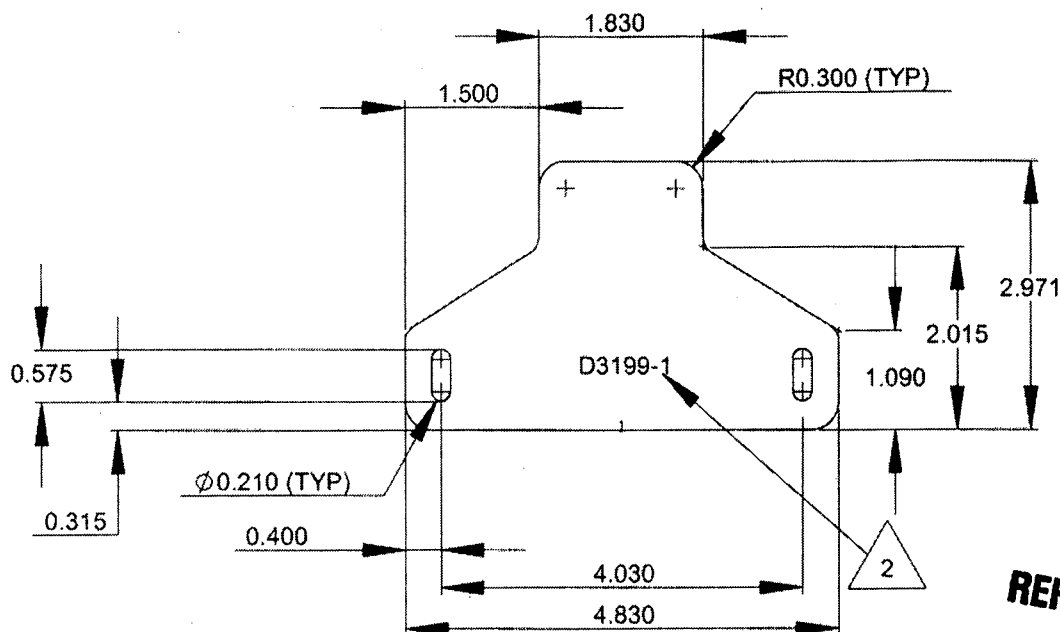
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



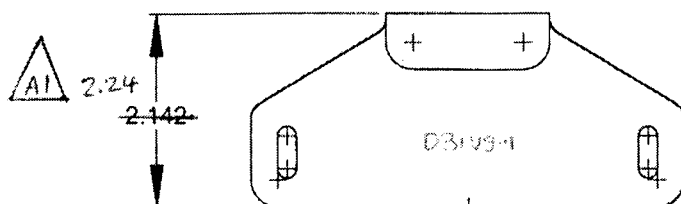
DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	A	APPROVED	A	DRAWING NO. D3199
DATE	03.08.05	TITLE	BRACKET	REV. A SHEET 1 OF 1
A	03.08.05	NEW ISSUE		SCALE 1:2
AI	04.03.01	2.24 WAS 2.142		

RELEASED
03.09.02



REFERENCE ONLY

D3199-1 FLAT PATTERN



D3199-1 BRACKET

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

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